

Work Order ID 86363

June-27-12 3:46:27 PM

86363

Page 1

Item ID: D2606

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Console Bracket, 206/407 Console

Start Date: 27/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/28

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2606

Rev A1

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

6 0 Jm 12-7-7

FLOW CNC Waterjet

1-Cut as per Dwg D2606 Dwg Rev: A1 Prog Rev: A1 2-
Deburr if necessary

2024 .040

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

6 0 Jm 12-7-7

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

8.26.109

(46)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86363

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

6

6

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

W/O:		WORK ORDER CHANGES					
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Work Order ID 86363

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86.36.3

Page 3

Item ID: D2606

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Console Bracket, 206/407 Console

Start Date: 27/06/2012 Start Qty: 6.00

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Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 6.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

C φ BL 12-7-16

Lex SP 12-7-17

12/7/18 JF
me 12-07-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 86363

86363

Parent Item: D2606

D2606

Parent Item Name: Console Bracket, 206/407 Console

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP D98.11.26Added InspectionDM
IPP Rev:E Now On Waterjet 07-03-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040		Purchased	No			100	sf	178.1612	0.1507	0.951789			
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M2024T3S 040

2024-T3 .040 sheet

**

1.0 SF

Jun 12-77

Location

Loc Qty

Loc Code

MAT022

178.1611626

120605

49.6627416

121197

32.498421

122136

96

122136

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86363
Description: Console Bracket		Part Number:	D2606
Inspection Dwg: D2606 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.841	+/-0.005	0.839"	✓		U	mm01
1.589	+/-0.005	1.592"	✓		U	"
0.621	+/-0.010	0.623"	✓		U	"
1.809	+/-0.010	1.806"	✓		U	"
2.430	+/-0.010	2.431"	✓		U	"
0.621	+/-0.010	0.620"	✓		U	"
8.309	+/-0.010	8.308"	✓		U	Producer
8.930	+/-0.010	8.930"	✓		U	"
8.710	+/-0.010	8.710"	✓		U	"
R0.250	+/-0.010	0.250"	✓		R.G	
R0.156	+/-0.010	0.156"	✓		RG	
Ø0.098	+0.005/-0.000	0.101"	✓		U	mm01
0.040	+/-0.005	0.040"	✓		U	"

Measured by:	Jm	Audited by:	S	Prototype Approval:	N/A
Date:	12-7-7	Date:	12/02/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

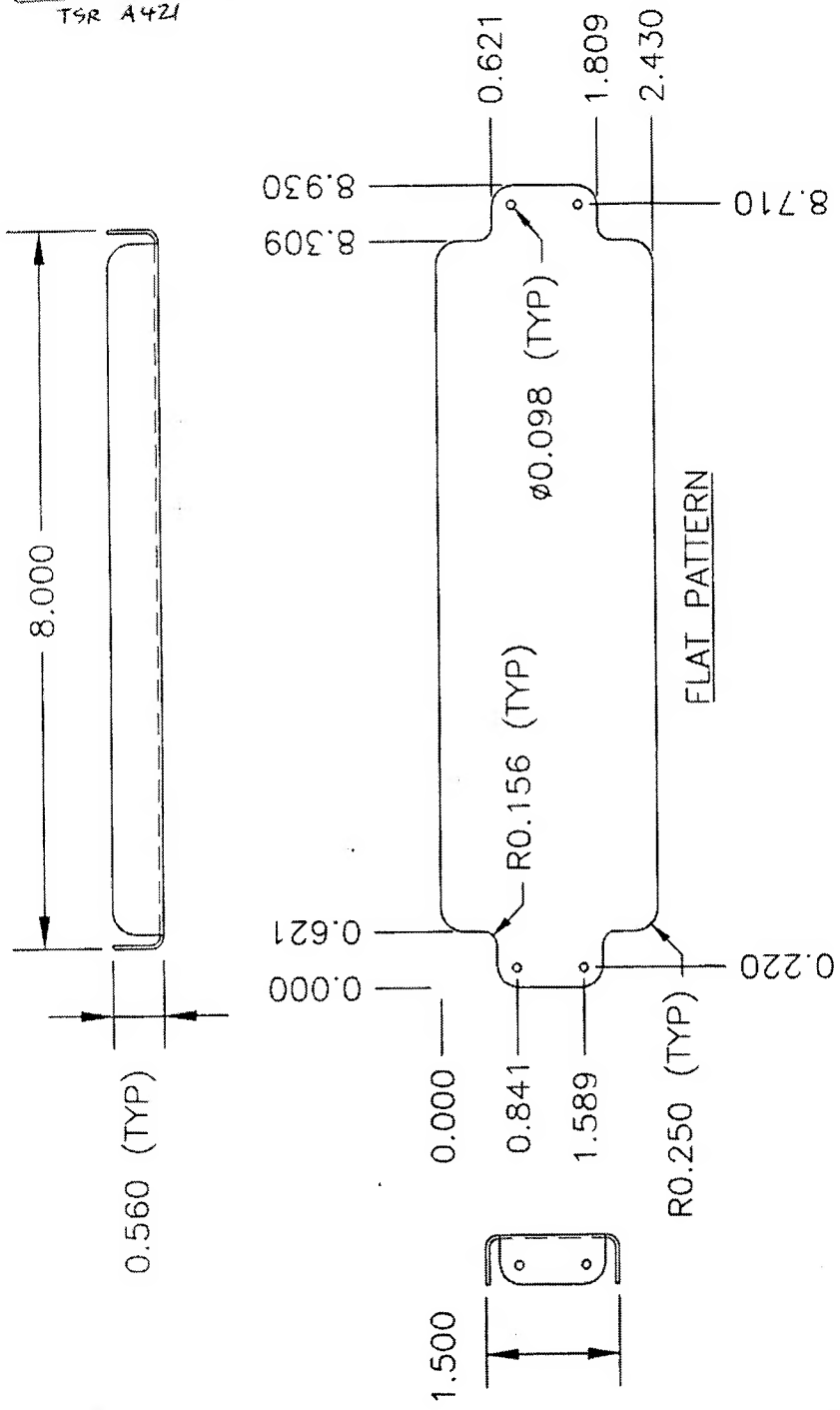
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NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
LE	Bw	D2606	SHEET 1 OF 1
DATE		TITLE	SCALE
97.10.23		CONSOLE BRACKET	1:2
A	97.10.23	D2606 WAS D206-547-27	
A1	02.06.04	ADD FINISH	

RELEASED
97.11.04 KE
TSR A421



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86363 MW
12/06/28

MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2606
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART Q51 W5 4.1 /A1

W/O:		WORK ORDER CHANGES					
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